

Date: Thursday, 5/25/2006 3:26:37 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CLAMP |
| Job Number | : 27244 | | |
| Estimate Number | : 10192 | | |
| P.O. Number | : N/A | Part Number | : D2171 |
| This Issue | : 5/25/2006 S.O. No. : N/A | Drawing Number | : D2171 REV. D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : PURCHASED PARTS | Drawing Revision | : D |
| Previous Run | : N/A | Material | : N/A |
| Written By | : <i>SEE COMMENT BELOW</i> | Due Date | : 6/15/2006 Qty: 100 Um: Each |
| Checked & Approved By | : <i>06.05.25</i> | | |
| Comment | : Est: F 01.11.29 Reformat SM/EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: *1352**C206105130**(100)*

Laser cut as per Dwg D2171

Material: 304/316 SS 0.063" thick

Material release note required

| | | |
|-----|--------|-------|
| 2.0 | D2171F | Clamp |
|-----|--------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 CLAMP

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

*Pack/2/5**(100)*

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK
 (4.158" center to center)

060705 (102)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2- Bend as per Dwg D2171

3- Tumble

*ALREADY BENT.**Sad 06:07:05 (102)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/25/2006 3:26:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 27244

Part Number: D2171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 06/07/05

102

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 219

P 06/07/05 102

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/05

102

Job Completion



U 06-07-05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

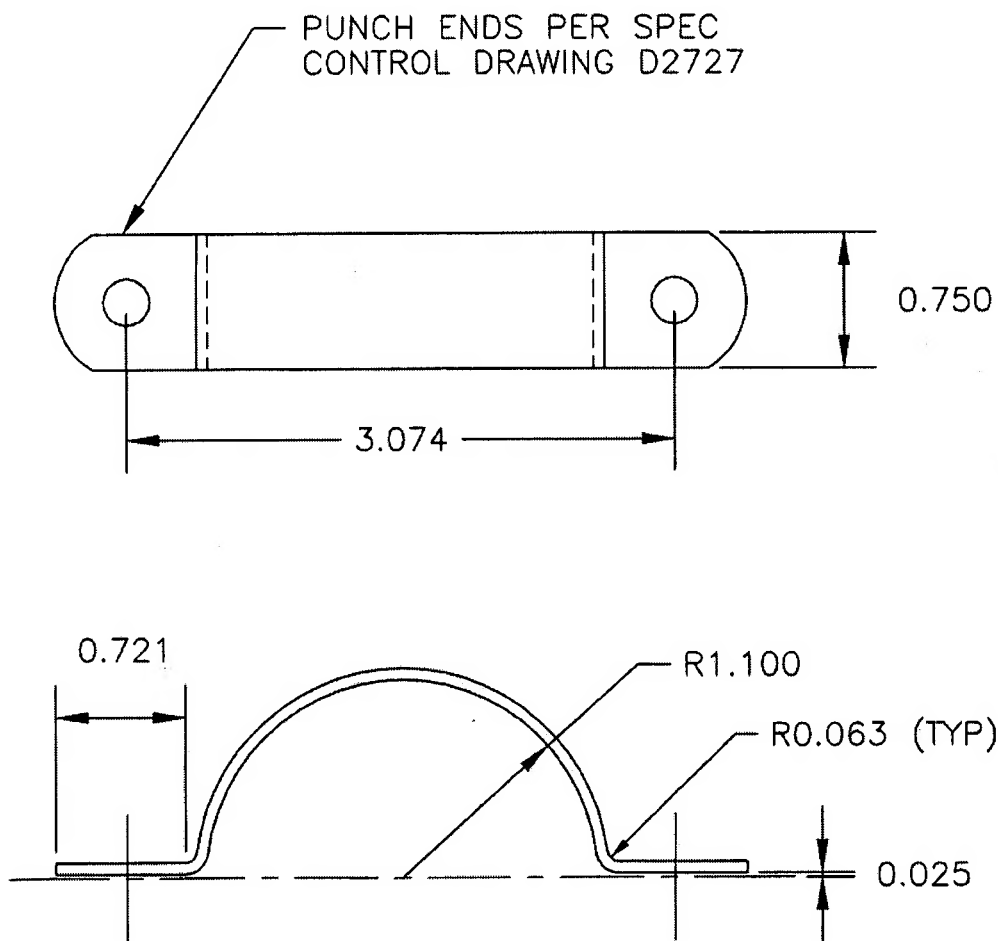
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|------------------|---------------------------|---|------------------------|
| DESIGN Bw | DRAWN BY MA | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CP | APPROVED KE | DRAWING NO. D2171 | REV. D SHEET 1 OF 1 |
| DATE 99.03.08 | TITLE CLAMP | | SCALE 1:1 |
| B | 96.01.29 | REDRAWN | |
| C | 97.05.14 | RADIUS CHANGED, CUSHION ADDED | |
| D | 99.03.08 | REMOVE CUSHION (TSR A890) 4.158 WAS 4.888 | |

RELEASED
99.03.11 KE



MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27244

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

| | | | | | | |
|-----------------|----------|----------------------|-------------|---------------------|---------|-----------|
| CERTIFICATE NO. | 1 | OUR JOB NO | J0144270 | SHIPPING MEMO | 0340503 | |
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME | DWG ISSUE |
| -- | 100 PCS | PO00001352 | D2171 | D | CLAMP | D |
| MATERIAL | | SUPPLIED BY | | MAT. REL. NO. | | |
| S.S.T 304 | | TW METALS / AK STEEL | | H/N # 7360176 ATT'D | | |

| | PROCESS | PROCESSOR | RELEASE NOTE # |
|---|---|-----------|----------------|
| 1 | FIRST ARTICLE INSPECTION REPORT ON FILE | GFI | CONFORMS |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 | | | |
| 7 | | | |
| 8 | | | |
| 9 | | | |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 JULY 2006

G.F.I. Q.C. REP.

B. Samiec



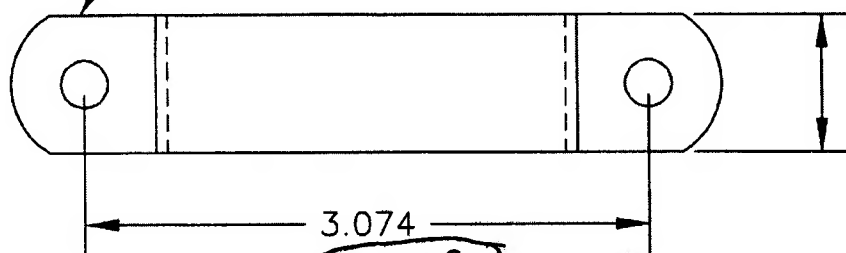


| | | | |
|------------------|----------------|---|------------------------|
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RELEASED
99.03.11 KE

PUNCH ENDS PER SPEC
CONTROL DRAWING D2727

✓ comply.



0.750

.752

3.074

3.083

0.725

0.721

MYLAR

R1.100

PLAN MAÎTRE

02 JUN 2006

R1.100

R0.063 (TYP)

R.062 TYP

0.025

0.025

061

MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE

